

Date: Thursday, 02/10/2008 10:34:30 AM
 User: Julie Leçocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR WINDOW
Job Number : 42411	
Estimate Number : 10457	
P.O. Number :	Part Number : D32121
This Issue : 02/10/2008 S.O. No. :	Drawing Number : D3212 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 33118	Material : Multiples of 4
Written By :	Due Date : 10/10/2008
Checked & Approved By : <u>JULIO 08.10.02</u>	Qty: 10 Um: Each
Comment :	
Est Rev: A New Issue 05-11-09 JLM	
Est Rev: B Water jet/ ecn798 06-05-08 EC	
est rev.C back on haas 07.04.09 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 1.0232 sf(s)/Unit Total: 10.2323 sf(s)
 Material: 0.125" Polycast Sheet
 (M-ACRYLIC-S.125)
 Identify as D3212-1
 Batch: 109570 18 8-10-20

2.0	WATER JET	FLOW WATER JET
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(Pb) →

Comment: FLOW WATER JET

1-Cut blankas per Dwg D3212

Dwg Rev: BProg Rev: B18 8-10-20

(15)

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA349 and Dwg D3212

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3212-1 PAR #: N/A Fault Category: Prod Sm. For NCR: Yes No DQA: 11 Date: 08.11.10
 (D350-567-031) Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11 Date: 08/11/11

NCR: 42411		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/21	4 20	During inspection found that ALL 15 parts have Blow outs around some holes.	<i>[Signature]</i>	Scrap - destroy all windows - Create CAROB - N/A	B 8-10-21	<i>[Signature]</i> 08/10/21	<i>[Signature]</i> 08/10/21	<i>[Signature]</i> 08/10/21
		R.C: <u>process</u> deviated.						

NOTE: Date & initial all entries *

Date: Thursday, 02/10/2008 10:34:30 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 42411

Part Number: D32121

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	D27281	Dart Logo Label - small
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Qty	Part #	Description	Batch
1	D2728-1	Dart Logo label	

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Deburr if necessary
- 2-Install label as per Dwg D3212
- 3- polish abrasion scratches if necessary..
- 4-Wrap in plastic wrap after inspection

Scrap

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42411
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	X			
6.367	+/-0.005	6.367	X			
0.625	+/-0.005	.625	X			
Ø0.156	+0.005/-0.001	.159	X			
R0.25	+/-0.030	.25				
8.150	+/-0.005	8.150	X			
3.750	+/-0.005	3.750	X			
0.313	+/-0.010	.315	X			
15.14	+/-0.030	15.14	X			
12.520	+/-0.005	12.520	X			
6.260	+/-0.005	6.260	X			
1.312	+/-0.005	1.315	X			
0.313	+/-0.010	.310	X			
3.750	+/-0.005	3.750	X			
8.150	+/-0.005	8.150	X			
8.462	+/-0.005	8.462	X			
9.09	+/-0.030	9.09	X			

Measured by: B	Audited by:	Prototype Approval: N/A
Date: 8-10-20	Date:	Date: N/A

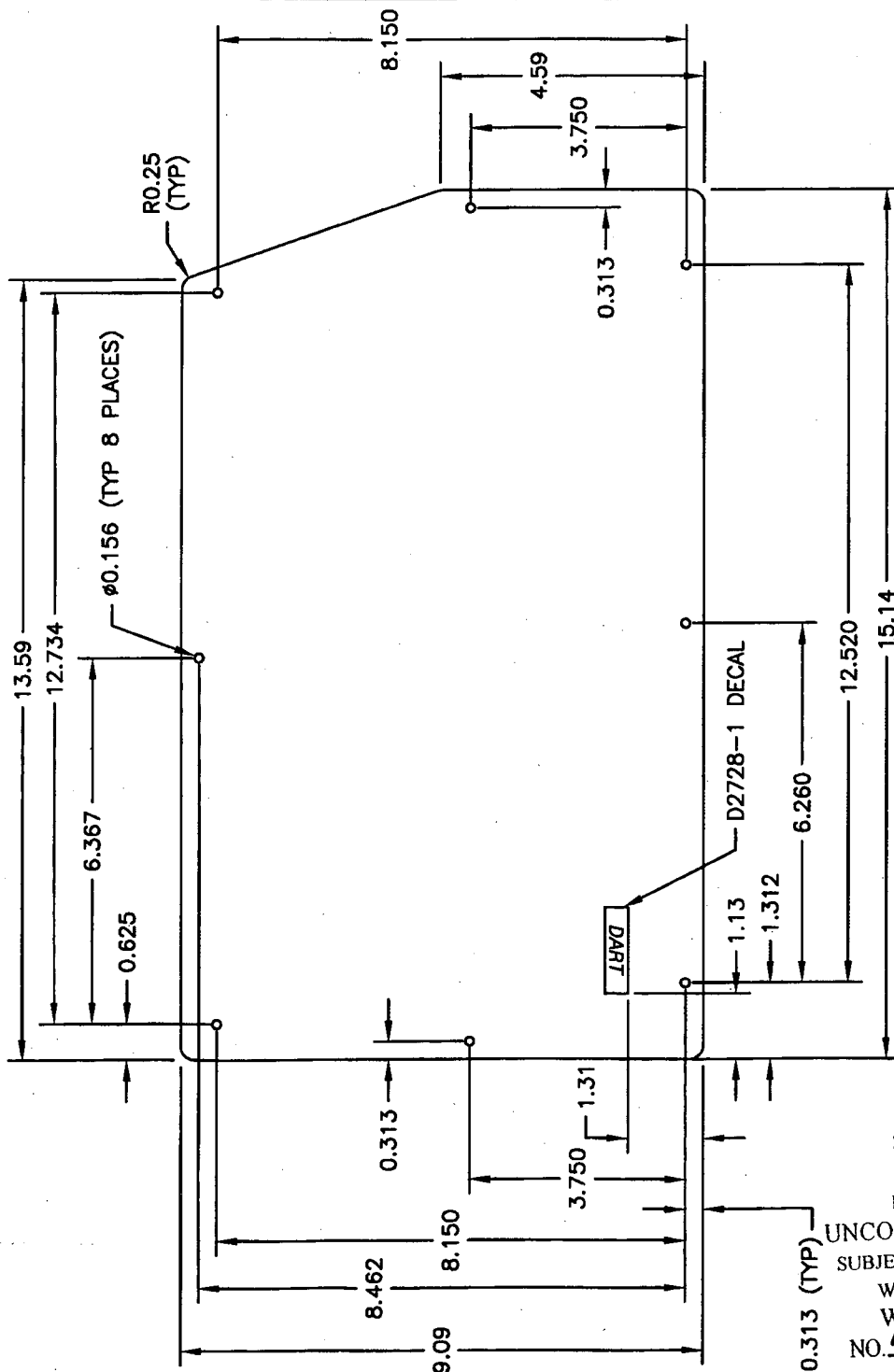
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	

DART

DESIGN CP	DRAWN BY SSH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3212	REV. B SHEET 1 OF 1
DATE 06.04.13	TITLE FLOOR WINDOW		SCALE 1:3
A	03.09.03	NEW ISSUE	
B	06.04.13	UPDATE MATERIAL PER NCR 029	

D3212-1 FLOOR WINDOW

- 1) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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WITHOUT NOTICE
WORK ORDER
NO. 42411

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